



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7810
Job Sheet 179369



Part No: 647.7810

Job Qty: 6 ea

Part Name: Bracket A



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev: A RQ 15.08.06 Verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	6 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Machining-1		K+ 2018-06-26
100	Bandsaw	6 pcs	6/22/18	6/22/18	0.00	0.19	Bandsaw1		K+ 2018-06-26
110	CNC Vertical Machining	6 pcs	6/22/18	6/22/18	0.30	5.13	HAAS1-1		K+ 2018-06-26
120	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC2 Machining-1		K+ 2018-06-26
130	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC8 Machining-1		K+ 2018-06-26
131	HandFinish	6 pcs	6/22/18	6/22/18	0.00	0.00	HandFinish2		Not Required m.s.
140	Outsource	6 pcs	6/22/18	6/22/18			ATG001-VC	5	CT 18-6-28
150	Packaging	6 pcs	6/22/18	6/22/18	0.00	0.00	Packaging2		CT 18-07-05
155	QC	6 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
180	Packaging	6 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1		CC 077A
190	QC21-SA	6 Ea	6/22/18	6/22/18	0.00	0.00	QC21		DAS 53 9-89

Part Op 100 - Cut Blank at 10.313"

Descriptions: 110 - 1-Machine per folio FB408

140 - Issue P/O to ATG : R0040356 Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	5.1540 ft (.859 ea)	90-Start up Operation	

6x 5066609

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X0.250	5	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket A	0.090inches $\pm$ 0.005	0.095 0.085		
2	Bracket A	45.000inches $\pm$ 0.500	45.500 44.500		
3	Bracket A	0.255inches $\pm$ 0.005	0.260 0.250		
4	Bracket A	9.810inches $\pm$ 0.010	9.820		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

			9.800	
5	Bracket A	0.260inches $\pm$ 0.010	0.270 0.250	Radius
6	Bracket A	29.900Degrees $\pm$ 0.500	30.400 29.400	Angle
7	Bracket A	3.671inches $\pm$ 0.005	3.676 3.666	
8	Bracket A	16.900Degrees $\pm$ 0.500	17.400 16.400	Angle
9	Bracket A	9.463inches $\pm$ 0.005	9.468 9.458	
10	Bracket A	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle
11	Bracket A	18.700Degrees $\pm$ 0.500	19.200 18.200	Angle
12	Bracket A	9.092inches $\pm$ 0.002	9.094 9.090	
13	Bracket A	3.332inches $\pm$ 0.002	3.334 3.330	
14	Bracket A	7.300inches $\pm$ 0.002	7.302 7.298	
15	Bracket A	0.397inches $\pm$ 0.002	0.399 0.395	
16	Bracket A	2.575inches $\pm$ 0.002	2.577 2.573	
17	Bracket A	2.475inches $\pm$ 0.002	2.477 2.473	
18	Bracket A	0.500inches $\pm$ 0.002	0.502 0.498	
19	Bracket A	0.400inches $\pm$ 0.002	0.402 0.398	

Plex 6/18/18 12:40 PM Dart.lajeunesse.marie

1270 Alderdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaerospace.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S084599



Part: 647.7810

Job No: 179369

Serial No/Batch: S084599

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/26/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040356

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040356
PO Date: 6/28/18
Due Date: 7/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178641	SWA10A-700	Wire Clamp -Issue P/O to ATG: _____ -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	7/13/18	40 pcs	0 pcs	40 pcs	\$8.00/pcs	\$320.00
2	179370	647.7811	Bracket B Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$16.75/pcs	\$67.00
3	179369	647.7810	Bracket A Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	6 pcs	0 pcs	6 pcs	\$16.75/pcs	\$100.50
4	168294	647.1814	Gusset LH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60
	168028			Firmed	7/13/18	10 pcs	0 pcs	10 pcs	\$9.15/pcs	\$91.50
Sub Total:						14	0	14		\$128.10

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38
9-89

5	173890	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	7/13/18	12 pcs	0 pcs	12 pcs	\$12.25/pcs	\$147.00
6	168295	647.1815	Gusset RH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60

Plex 7/3/18 8:11 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T1
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
40 ea	Part: SWA10A-700 Wire Clamp Hard Anodize per MIL-A-8625F, Type III, Class 2, Black, .0005-.0045" (.5 - 4.5mils) Job: 23372		Rev: 4 PO: PO040356 Line: 1
4 ea	Part: 647.7811 BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23373		Rev: A PO: PO040356 Line: 2
6 ea	Part: 647.7810 Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23374		Rev: A PO: PO040356 Line: 3
14 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23375		Rev: A PO: PO040356 Line: 4 7
4 ea	Part: 647.1815 Gusset RH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23380		Rev: A PO: PO040356 Line: 6
Made in Canada.			

Made in Canada.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>4/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
DAS 38 9-89			
Made in Canada.			